

Date: Friday, 8/4/2006 10:00:59 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING
Job Number	: 28091		
Estimate Number	: 10091		
P.O. Number	: N/A	Part Number	: D31835
This Issue	: 8/4/2006 S.O. No. : N/A	Drawing Number	: D3183 REV. C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: C1
Previous Run	: N/A	Material	: N/A
Written By	: <u>SAA COMMENT BELOW</u>	Due Date	: 8/11/2006
Checked & Approved By	: <u>06.08.04</u>	Qty:	50 Um: Each
Comment	: Est: A 03.03.27 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 1778C206/08/04

Bearing as per Dwg D3183

Single row, deep groove, Conrad type, shielded

Possible Supplier: NSK P/N 6800ZZ

Certificate of conformity note is required

(50)

2.0

6800ZZ

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

BEARING

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

AL 06/08/04 (50)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-08-08 (50)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST412AL 06/08/04 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 13 Date: 26/08/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 8/4/2006 10:00:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 28091

Part Number: D31835

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SD 06/08/10 (50)

Job Completion



u 8008-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

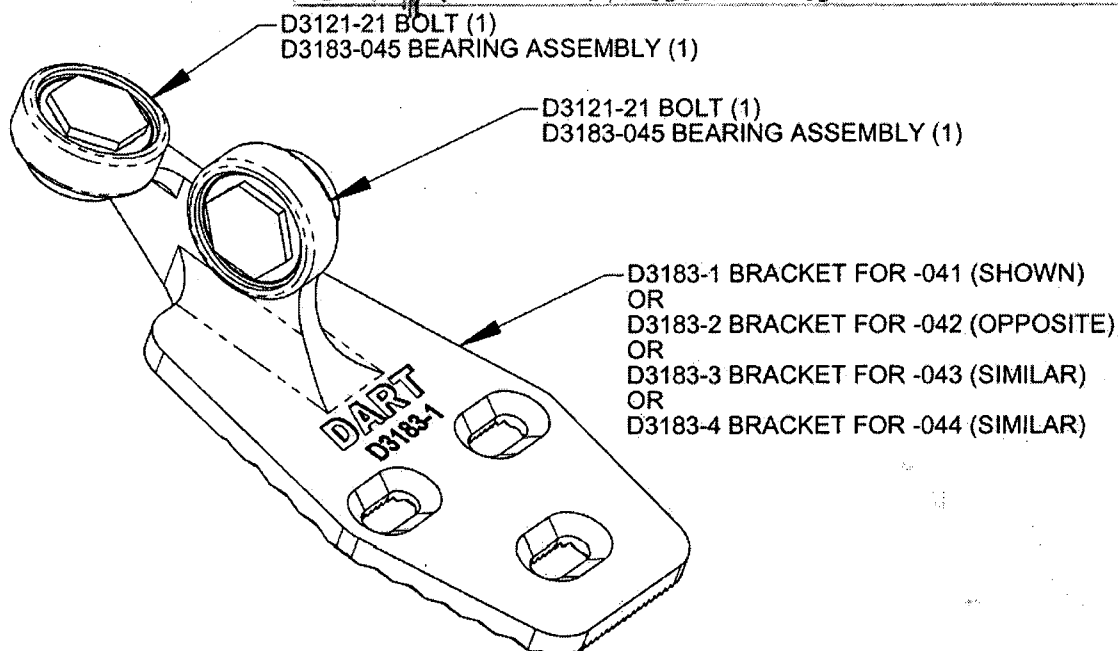
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

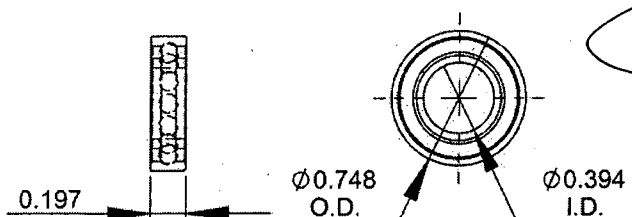


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	# 04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01



D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



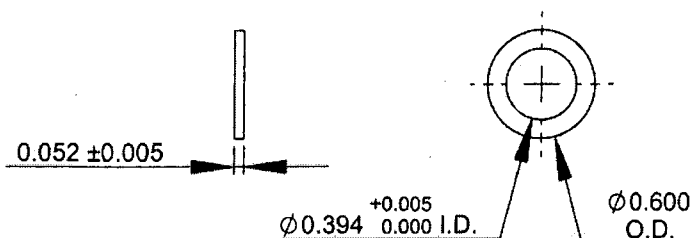
D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

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NO. 28091

D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R)
ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



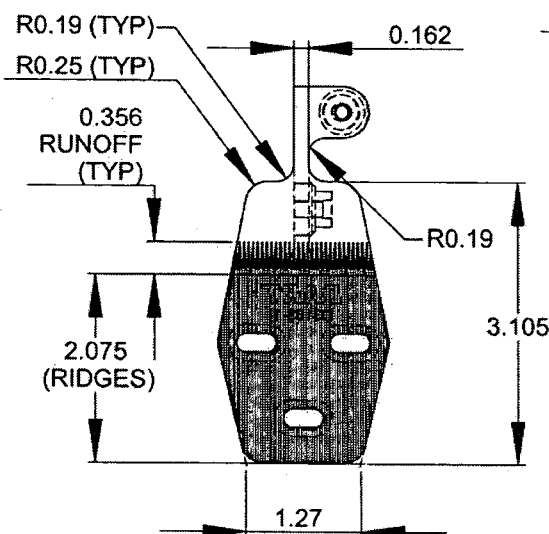
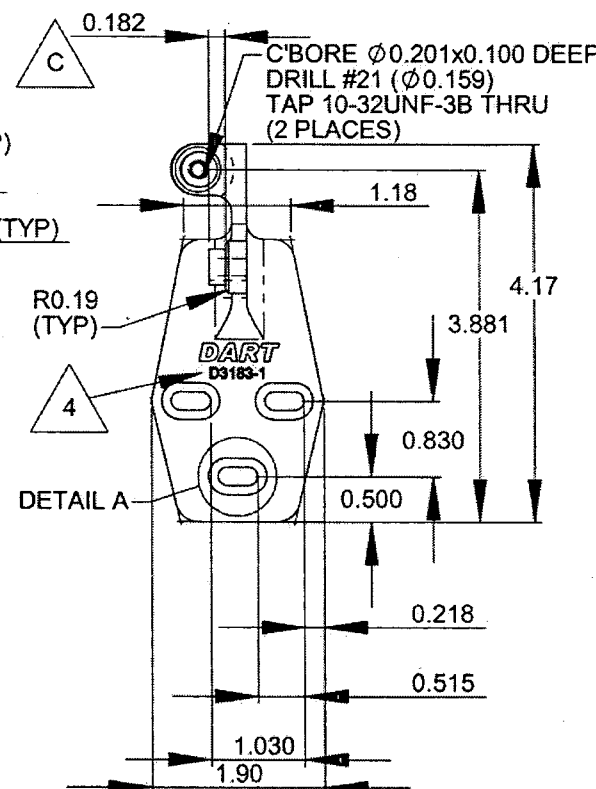
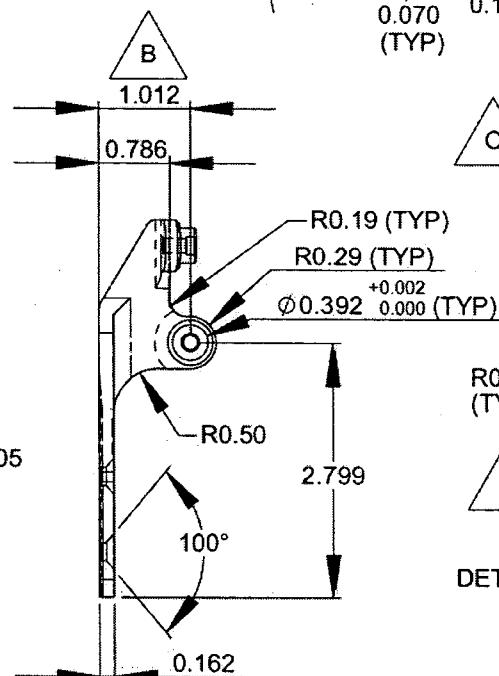
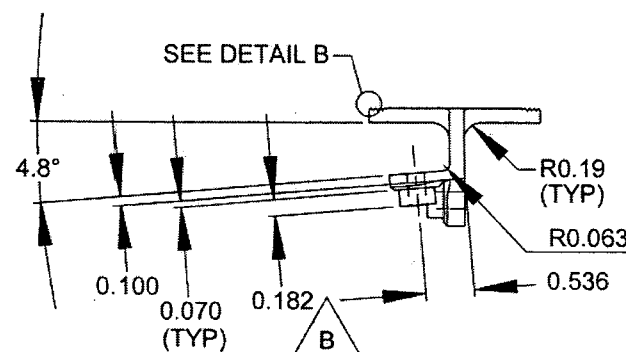
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DATE 04.02.17	TITLE	REV. C
	D3183	SHEET 2 OF 4
	BRACKET ASSEMBLY	SCALE 1:2

RELEASED
04.03.01



**D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE**

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

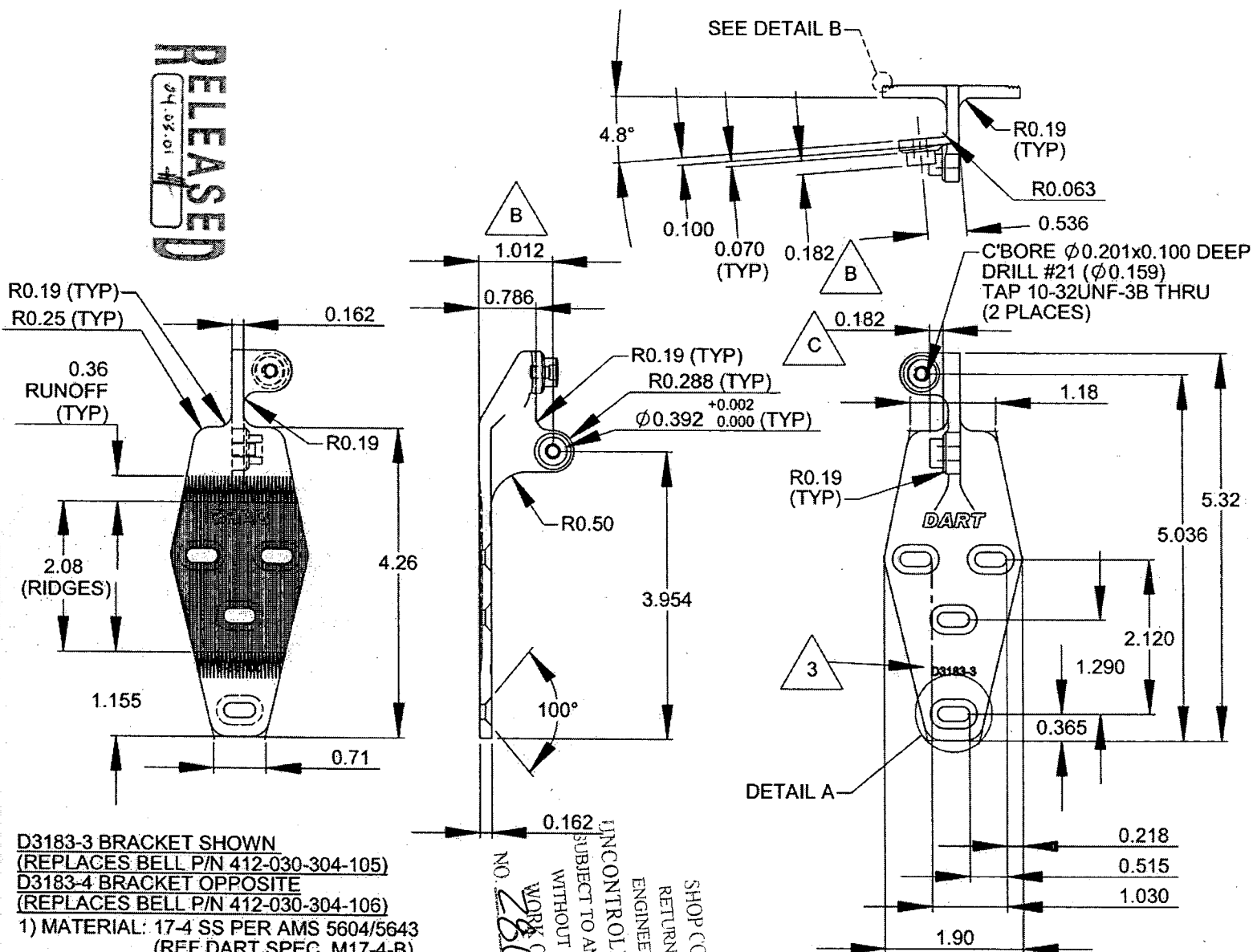
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		D3183	SHEET 3 OF 4
DATE	TITLE		SCALE
04.02.17	BRACKET ASSEMBLY		1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

0.162
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NO. 28031
is

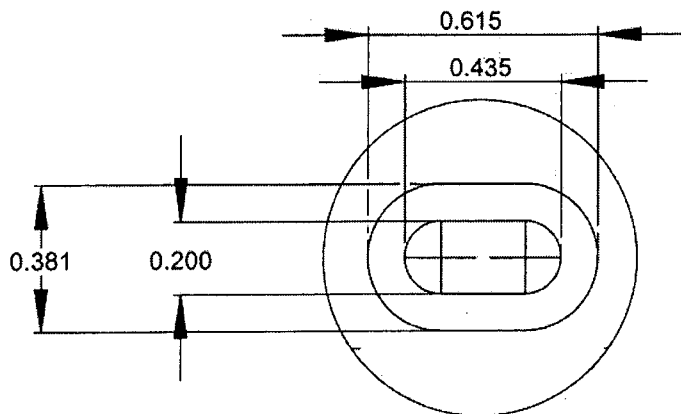
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DECLASSIFIED
DATE 01-03-01 BY [signature]

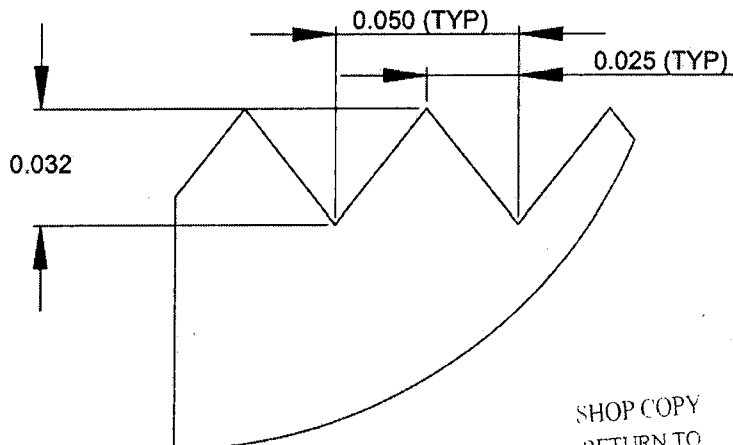


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SCALE 1:1	



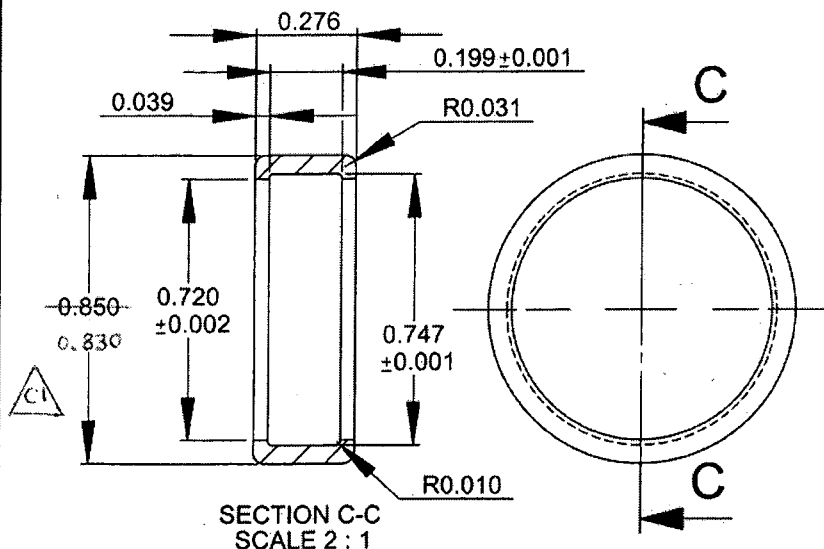
DETAIL A (2 : 1)

RELEASED
04.03.01 *[Signature]*



DETAIL B (20 : 1)

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NO. **28091**)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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0002222

General BEARING SERVICE Inc.

www.gbs.ca

386 MAIN ST E, HAWKESBURY, ONTARIO K6A 1A8 (613) 632-9914

ORDER DATE: AUG 8, 2006

Cle GENERAL BEARING SERVICE INC

GST # R101979094

SOLD TO: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY, ON.

K6A-1K7

SALE MADE BY: PD
SHIP VIA:

CUSTOMER ORDER #: P000001778

PST LICENCE: 6122-5207

PRODUCT	DESCRIPTION	SOLD	SHIP	PRICE	EXTENSION
6800-27	BALL BEARING	50	50	4.89	244.50
6900-27	BALL BEARING	50	50	4.97	248.50
				G.S.T.	29.58

[Handwritten signature]

RECEIVED BY: *[Handwritten signature]*

PACKING SLIP NO: 223164-0 **

THIS FORM MUST BE COMPUTER PRINTED TO BE VALID E & O E
DOIT ETRE IMPRIME PAR ORDINATEUR POUR ETRE VALIDE E & O E